

CLAMP DEVICE AND CLAMP METHOD FOR
HEAT-TREATED ARTICLE

ABSTRACT

A heat treatment operation can be executed, suppressing a wave-shaped deformation at a non heat-treatment region of an article to be heat treated.

—To an elongated-shaped article to be heat treated (10) to which a raised portion (11) extending in the longitudinal direction is formed, a hardening region, ~~as being a heat-treated region defined to be extended~~extend in a longitudinal direction at a part of the raised portion (11), and a non-hardening region, ~~as being a non-heat-treated region defined to be extended~~extend in the longitudinal direction at flange portion (13), and other parts of the raised portion (11) are arranged side by side in a width direction orthogonal to the longitudinal direction. The flange portion (13) is clamped by a first and a second ~~clamping means~~clamp (22), (23) arranged in the longitudinal direction, and one first ~~clamping means~~clamp (22) is a tight ~~clamping means~~clamp for holding fixedly the flange portion (13) and a plurality of second ~~clamping means~~clamps (23) are loose ~~clamping means~~clamps for clamping loosely the flange portion (13), allowing the article to be heat treated (10) to be convex on the side of the heated hardening region.